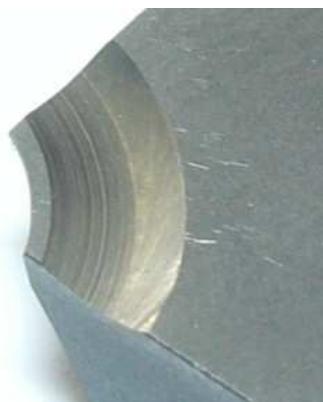


## Insert Z4, concentric Chipbreaker DI 22.35

A08-350

A circular chipbreaker is ground concentric with respect to the concave radius of the chamfering Insert. In addition a k-land operation is done along the concave radius. All operations are executed in one setup using the TTC clamping system.



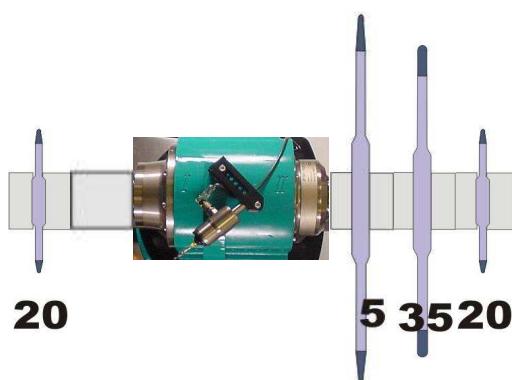
### 1. Cycletime for Production

Tool specifications					
Concave Radius 5 mm, BxH 22.35x22.35					
Material CARBIDE					
Operations	Probe	Chipbreaker	2. Clr	1. Clr	K-Land
Feed [mm/Min]	2000	200	35	60	90
Power [kW]		1	1	2	1
Cutting feed [m/s]		18	22	22	22
Used wheels		20	35	5	20
Grinding time [s]	5	62	117	95	85
Total cycle time	6 Min 23				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

20	14EE1 Ø40 D64
35	14F1 Ø150 D76
5	14EE1 Ø200 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

responsible engineer: OP,31.10.08

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